

Date: Wednesday, 7/11/2007 2:46:30 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ACCESS PANEL ASSEMBLY
 Job Number : 33475
 Estimate Number : 12546
 P.O. Number : N/A Part Number : D3256041
 This Issue : 7/11/2007 S.O. No. : N/A Drawing Number : D3256 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 30149 Material : N/A
 Due Date : 7/27/2007 Qty: 4 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue 06-10-03 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S22GA 304/316 .032 Sheet



Comment: Qty.: 0.9870 sf(s)/Unit Total : 3.9480 sf(s)

304/316 .032 Sheet

Batch: M105061

HB 07-07-30

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3256

Dwg Rev: B

Prog Rev: B

HB 07-07-30

④

2-Deburr if necessary

SAD 07/07/30

④

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 07-07-30

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ES 07/07/30 ④

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE Form using D3256-1T2

FF 07-09-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:46:30 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 33475

Part Number: D3256041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Added on tank length

Comment: INSPECT WORK TO CURRENT STEP

En 07/09/05

(+4)

7.0

D32563

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Gasket

Batch: *B30307*

FF 07-09-05 4

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install D3256-3 gasket using 3M Scotch-grip adhesive as per Dwg D3256

A/R 1300/1300L 3M Adhesive Batch: *M102890*

FF 07-09-05 4

2-AFTER CURING, transfer holes from D3256-1 into D3256-3.

FF 07-09-13 4

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/13 (+4)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/9/13 SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)
07/09/14

Job Completion



u 07/09/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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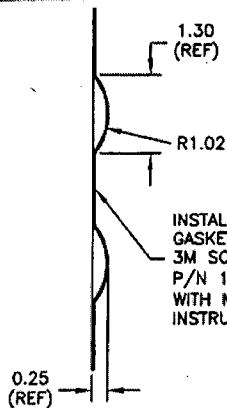
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3256	REV. B SHEET 1 OF 3
DATE 05.06.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	05.06.27	D3256-3 DIM 1.30 WAS 0.65	

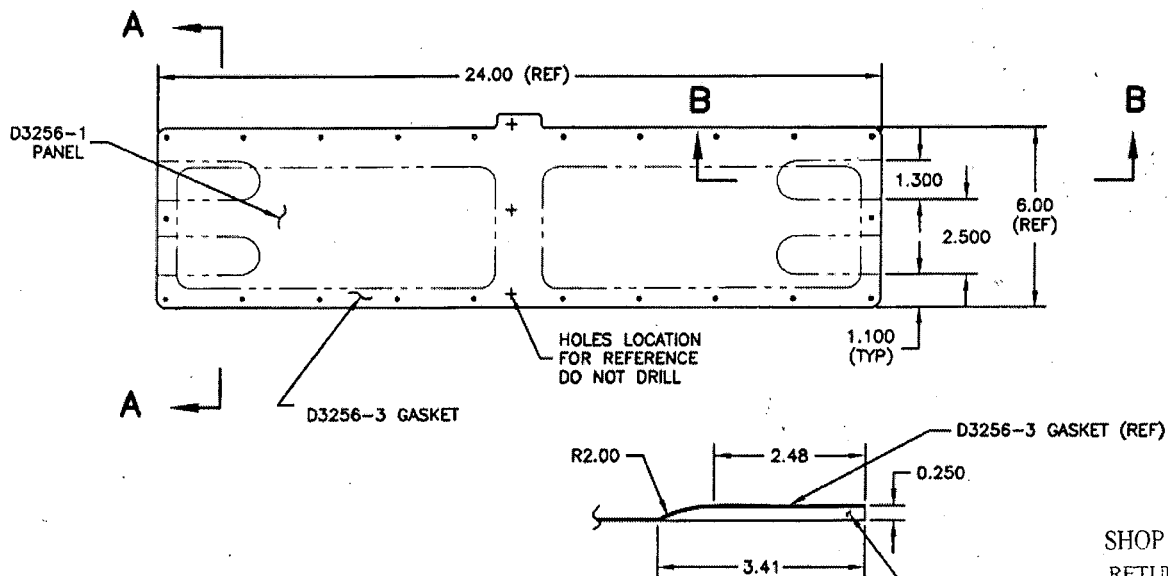
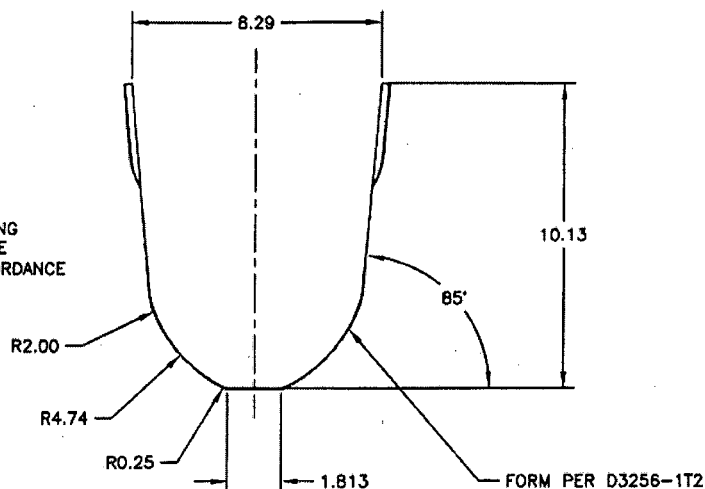
RELEASED

05.06.30 *[Signature]*



INSTALL D3256-3
GASKET ON THIS SIDE USING
3M SCOTCH-GRIP ADHESIVE
P/N 1300/1300L IN ACCORDANCE
WITH MANUFACTURE'S
INSTRUCTIONS

VIEW A-A
SCALE 1:3



VIEW B-B
SCALE 1:3

D3256-041 ACCESS PANEL ASSEMBLY

1) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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WITHOUT NOTICE
WORK ORDER
NO. 33475

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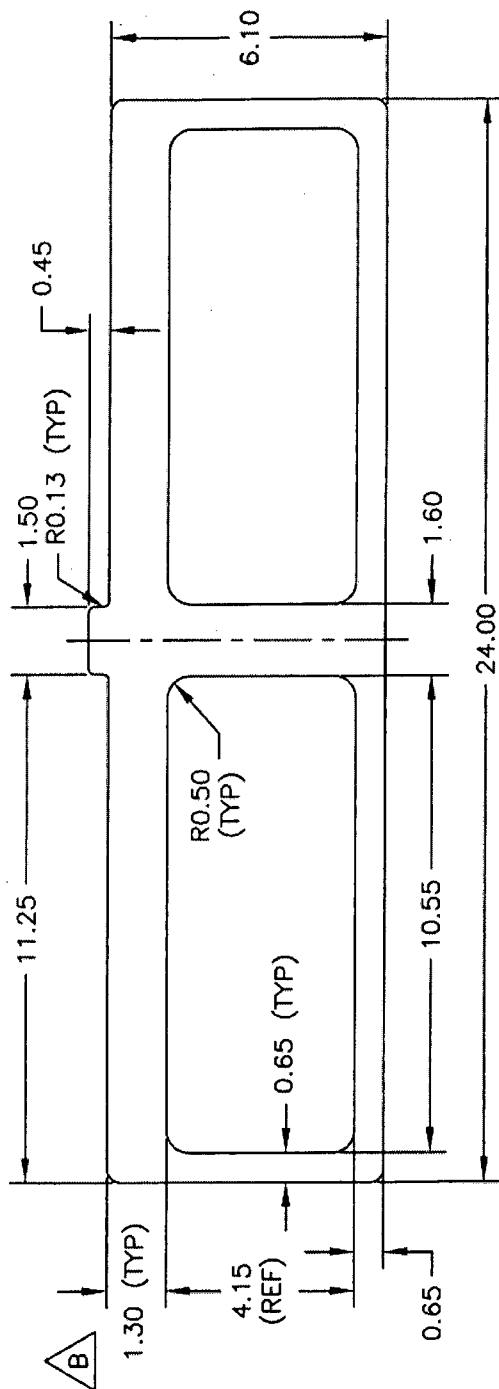
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3256	REV. B SHEET 3 OF 3
DATE 05.06.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4



RELEASED

05.06.30 *[Signature]*

D3256-3 GASKET

D3256-3 NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET 0.035 THICK
MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2)
OR MIL-G-12803A (GRADE P-1161A)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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NO. **33475**

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DART AEROSPACE LTD		Work Order: 33475
Description: ACCESS PANEL ASSEMBLY		Part Number: D3256
Inspection Dwg: D3256	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.000	+/- .010	6.000	*			
5.700	+/- .010	5.700	*			
3.000	+/- .010	3.000	*			
.300	+/- .010	.300	*			
.300	+/- .010	.300	*			
2.850	+/- .010	2.850	*			
5.400	+/- .010	5.400	*			
7.950	+/- .010	7.950	*			
10.500	+/- .010	10.500	*			
13.500	+/- .010	13.500	*			
16.050	+/- .010	16.050	*			
18.600	+/- .010	18.600	*			
21.150	+/- .010	21.150	*			
23.700	+/- .010	23.700	*			
24.000	+/- .010	24.000	*			
11.250	+/- .010	11.250	*			
12.750	+/- .010	12.750	*			
6.450	+/- .010	6.450	*			
φ .128	+ .005 - .001	.130	*			
.032	+/- .010	.034	*			

Measured by: B	Audited by: E	Prototype Approval:
Date: 07-07-30	Date: 07/07/30	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	